

Date: Monday, 12/01/2009 2:38:32 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STEP SPACER
Job Number :	44694		
Estimate Number :	13129		
P.O. Number :		Part Number :	D37202
This Issue :	12/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3720 REVA
First Issue :	/ /	Project Number :	N/A
Previous Run :	44293E	Drawing Revision :	A
Written By :		Material :	
Checked & Approved By :	JUD 09.01.13	Due Date :	06/02/2009
Comment :	Est Rev :A New Issue 08-01-11 EC verified by DD		

Qty: 16 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
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Comment: Qty.: 0.0893 sf(s)/Unit Total : 1.0710 sf(s)
 6061 T6 sheet .125
 Batch: 110405

ml 09.04.02

(22)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3720
 Dwg Rev: A
 Prog Rev: A

2-Deburr if necessary

ml 09 04 03

(22)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml 09 04 03

(22)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

809/04/03

(22)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 C'sink as per dwg D3720

E 809/04/07

(22)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3720-2 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: 12 Date: 09/04/15
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 44694		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/4/15	# 2.0	Found one part with a cut # in the middle of part from water jet LC machine malfunction	<i>[Signature]</i>	SCRAP and Destroy Replac Qty <u>10</u> M# <u>1110405</u>	<i>[Signature]</i> 09/04/03 ①	<i>[Signature]</i> 09/04/15	<i>[Signature]</i> 09/04/15	<i>[Signature]</i> 09/04/15

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:38:32 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 44694

Part Number: D37202

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 07/04/07 (22)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MF

09/04/07

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SP 09-04-7 (22)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: DEVR

SP 09/04/08 (22)

10.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

09/04/13

Job Completion



MF 09-04-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DART AEROSPACE LTD		Work Order: 44094
Description: Step Spacer		Part Number: D3720-2
Inspection Dwg: D3720	Rev: A	Page 1 of 1

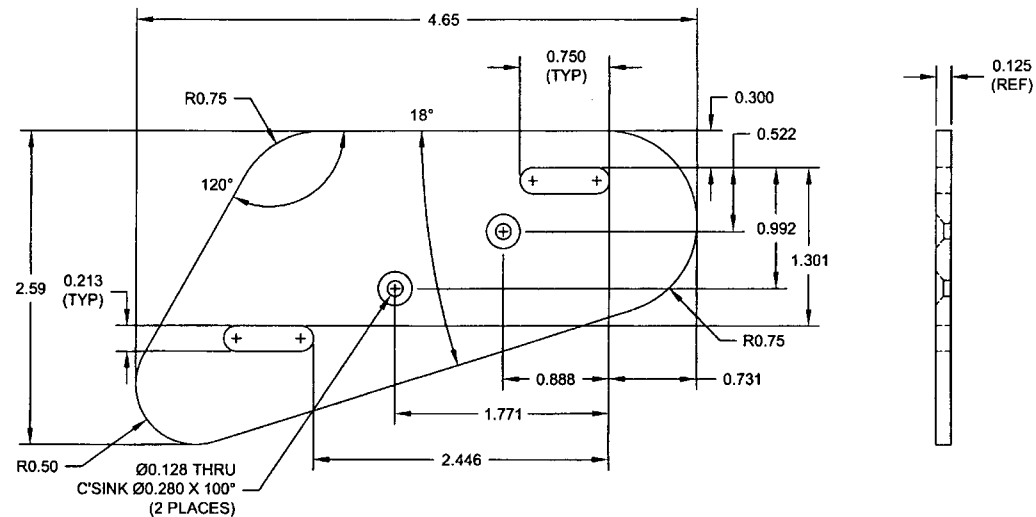
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

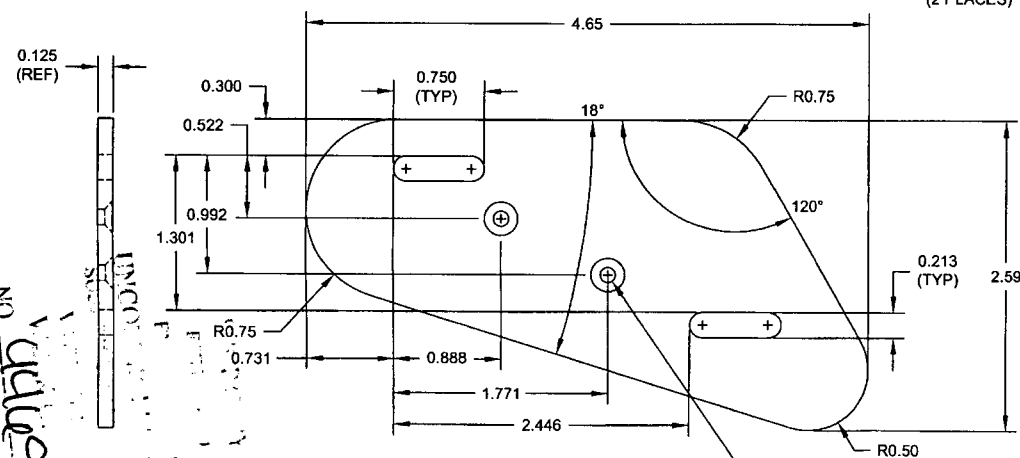
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	0.130	✓		vern	
4.65	+/-0.030	4.68	✓		vern	
2.59	+/-0.030	2.575	✓		vern	
0.750	+/-0.010	0.750	✓		vern	
0.300	+/-0.010	0.300	✓		vern	
0.522	+/-0.010	0.523	✓		vern HG	
0.992	+/-0.010	0.998	✓		HG	
1.301	+/-0.010	1.300	✓		HG	
0.731	+/-0.010	0.732	✓		HG	
0.888	+/-0.010	0.888	✓		H-G	
1.771	+/-0.010	1.770	✓		H-G	
2.446	+/-0.010	2.445	✓		HG	
0.213	+/-0.010	0.215	✓		vern	

Measured by: MM. MT	Audited by: S	Prototype Approval:	N/A
Date: 09/04/03	Date: 09/04/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.29	New Issue	KJ/DD	DA



D3720-1 STEP SPACER



D3720-2 STEP SPACER

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR -T62) ALUMINUM SHEET 0.125 THICK (PER QQ-A-250/11 OR AMS 4025/4027) (REF DART SPEC M6061T6S.125)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.08 lbs

RELEASED

A NEW ISSUE		PH	07.12.27
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.12.27		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3720
REV. A
SHEET 1 OF 1
TITLE STEP SPACER
SCALE 1:1

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